



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D3016-17
Job Sheet 182043



Part No: D3016-17

Job Qty: 20 ea ⁴⁰ ^{DAS} ²¹ ⁹⁻⁸⁹

Part Name: Gusset



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/16/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP B 03.05.09 Reformat KJ/RF IPP Rev:C 08-04-11 now made on water jet DD verified by:EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		8/31/18	0.00	0.00	Start Up Waterjet		<u>21</u> 18/08/17
100	Waterjet	20 pcs		8/31/18	0.00	0.68	Waterjet1		<u>21</u> 18/08/17 ³⁸ ⁹⁻⁸⁹
120	QC	20 pcs		8/31/18	0.00	0.00	QC8		
130	Packaging	20 pcs		8/31/18	0.00	0.00	Packaging3		<u>21</u> ³⁸ ⁹⁻⁸⁹
140	QC21-SA	20 Ea		8/31/18	0.00	0.00	QC21		<u>21</u> ³⁸ ⁹⁻⁸⁹

Part Op 100 - 1-Cut as per Dwg D3016

Descriptions: 130 - Identify and bag with light oil (Vactra oil #2), then Stock *****STOCK IN LARGE FAB*****

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NS.049	4130 Sheet .049	.3460 sf (.0173 ea)	90-Start up Operation	<u>21</u> 18/08/17

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4130NS.049	0	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Gusset	1.500Inches ± 0.030	1.530 1.470		
2	Gusset	1.530Inches ± 0.030	1.560 1.500		
3	Gusset	0.150Inches ± 0.030	0.180 0.120		
4	Gusset	0.150Inches ± 0.030	0.180 0.120		
5	Gusset	0.049Inches ± 0.010	0.059 0.039		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Approved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	
Date : _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work				Completed By	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaero.com Container No: S103200 Part: D3016-17 Job No: 182043 Serial No/Batch: S103200 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 08/17/18				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause					
Environment ☐	No Re-v ☐	Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaero.com Container No: S103200 Part: D3016-17 Job No: 182043 Serial No/Batch: S103200 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 08/17/18			
Design ☐	Operate ☐				
Doc/Data ☐	Offset/Setup ☐				
Equip/Tooling ☐	Supplier ☐				
Handling/Pre ☐	Training ☐				
Material ☐	Use for Testing ☐				
Internal Transport ☐	Poor Information ☐				
Tribal Knowledge ☐	Rushing ☐				
LOA ☐	Product Improvement ☐				
Substation ☐	Process Improvement ☐				
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐				
OTHER : _____					
		Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Inspection incorrect Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes s/Surge gram stock Pulled sequence Off-set Mislabeled Fit/Function Misaligned/off center Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence			